

Date: Wednesday, 11/07/2007 8:41:23 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 33332		Part Number	: D33154		
Estimate Number	: 10749		Drawing Number	: D3315 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	11/07/2007	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	11	Type : SMALL /MED FAB	Due Date	31/07/2007	Qty:	6 Um: Each
Previous Run	: 33332					
Written By	:					
Checked & Approved By	:					
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S16GA	1010/1025/A21/6aA SHEET Comment: Qty: 2.4108 sf(s)/Unit Total: 14.4648 sf(s) 1010/1025/A21/6aA SHEET .060" THK BATCH: <u>1105261</u> SAD 07/08/16
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3315 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary 07/08/22 BY SAN 07/08/16
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAN 07/08/16
4.0	QC8	SECOND CHECK Comment: SECOND CHECK En 07/09/19
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE 1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: <u>B</u> SB 07/09/19

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Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC6	DIMENSIONAL CHECK <i>En st 09/19 (8) counters</i>
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 <i>FC 01 09/21 (8)</i>
8.0	QC9	VISUAL WELDING INSPECTION <i>07-10-01 (3)</i>
9.0	POWDER COATING	POWDER COATING <i>M 104846</i>
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>07-10-02 (8)</i>
11.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>07-10-03 (8)</i>
12.0	QC21	FINAL INSPECTION/W/O RELEASE <i>07-10-03 (8)</i>

Job Completion



U 07/10/08

Date: Monday, 7/9/2007 11:42:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 33332		Part Number	: D33154		
Estimate Number	: 10749		Drawing Number	: D3315 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/9/2007	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: PURCHASED PARTS			
Previous Run	: 26187		Due Date	: 7/30/2007		Qty: 6 Um: Each
Written By	:					
Checked & Approved By	: <u>7/9/07.09</u>					
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING  <i>M105166-A 2.2005</i> <i>W.L. JLM</i>
Comment: PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3315 Possible Supplier: Industrial Laser Material release note is required		
2.0	D33154F	Wearplate Flat Pattern 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) WEARPLATE		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK 
Comment: DIMENSIONAL CHECK Inspect dimensions as per inspection template D3315-4T1		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33332

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: _____

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	_____

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-4, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:42:15 AM
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Drawing Name: WEARPLATE

Job Number: 33332

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

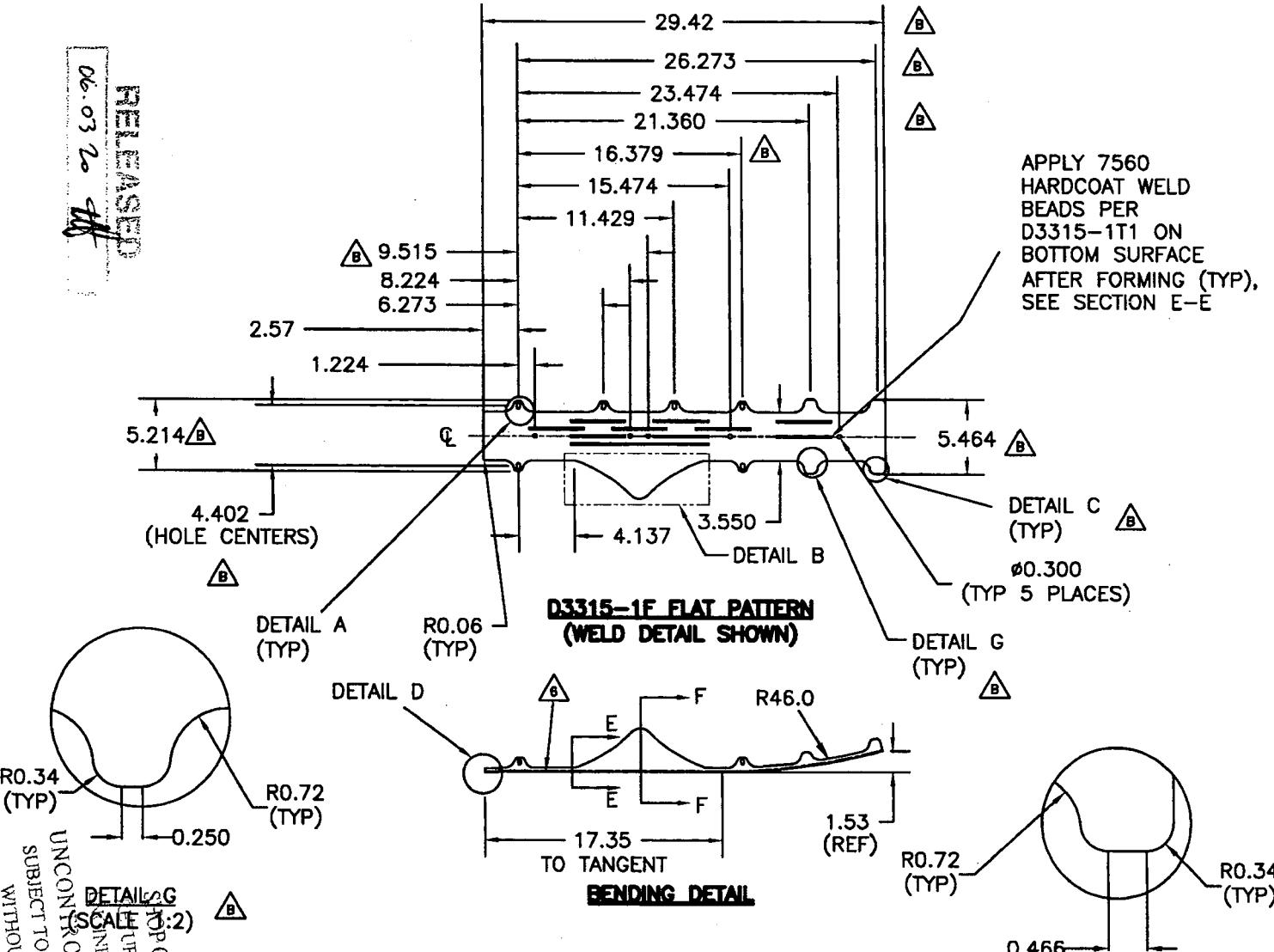
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

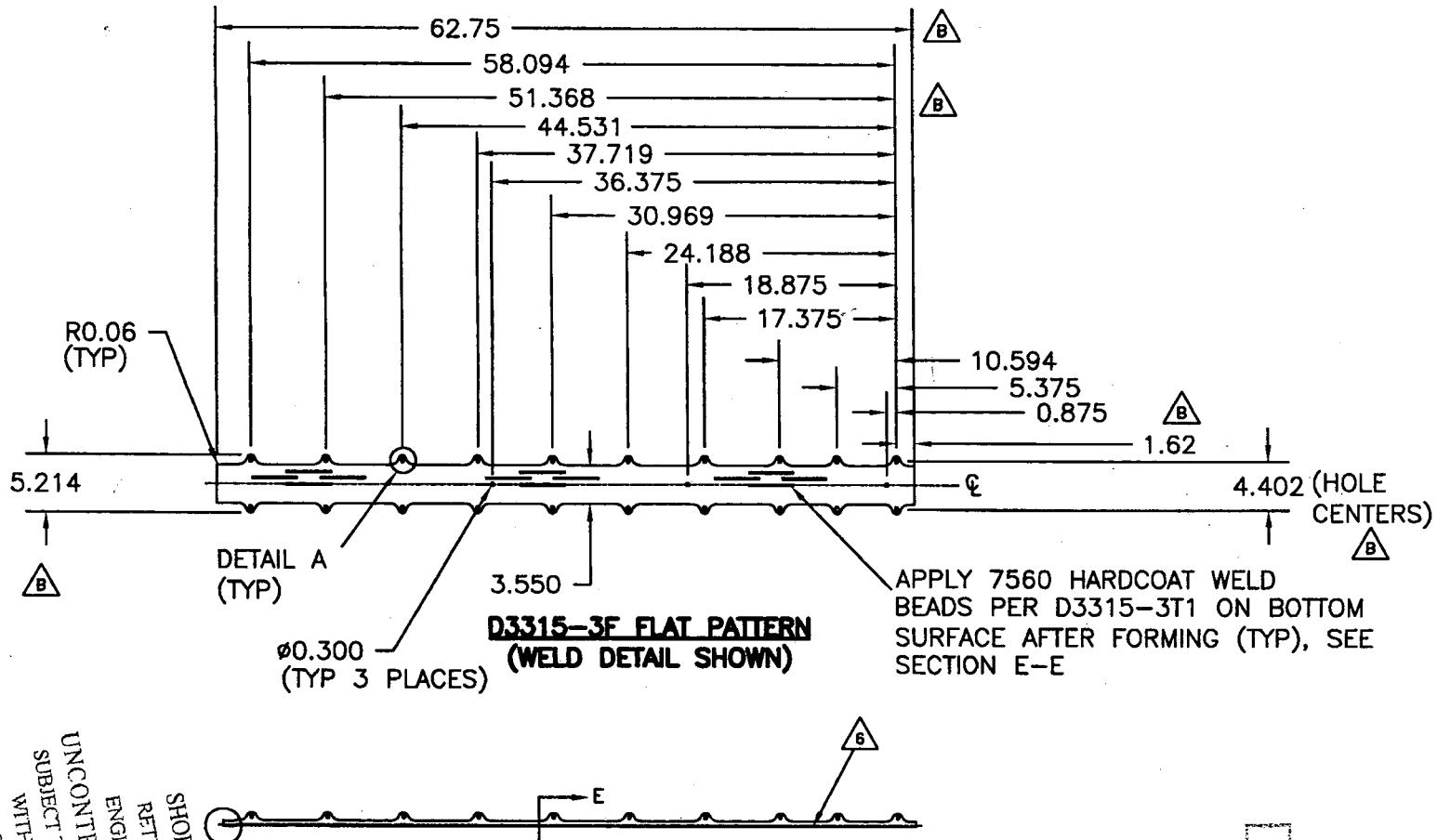
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3315	REV. B
DATE 06.01.31		TITLE WEARPLATE	SHEET 1 OF 4
A 06.01.31	04.09.10	NEW ISSUE	
B 06.01.31		UPDATE DIMENSIONS	

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 3332

D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 WELD PER DART QSI 004
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
 *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"



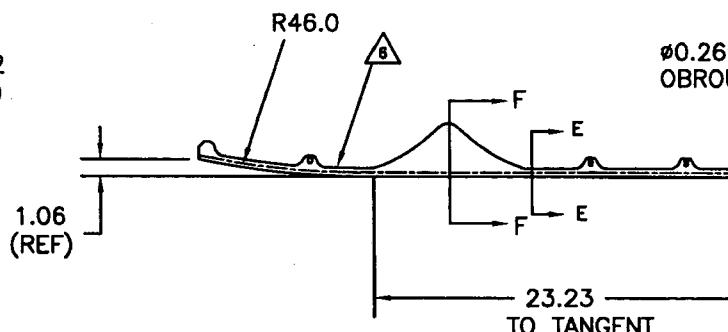
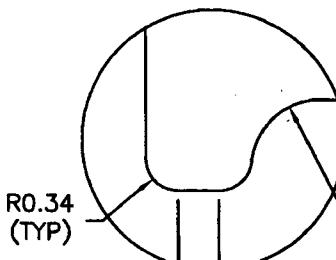
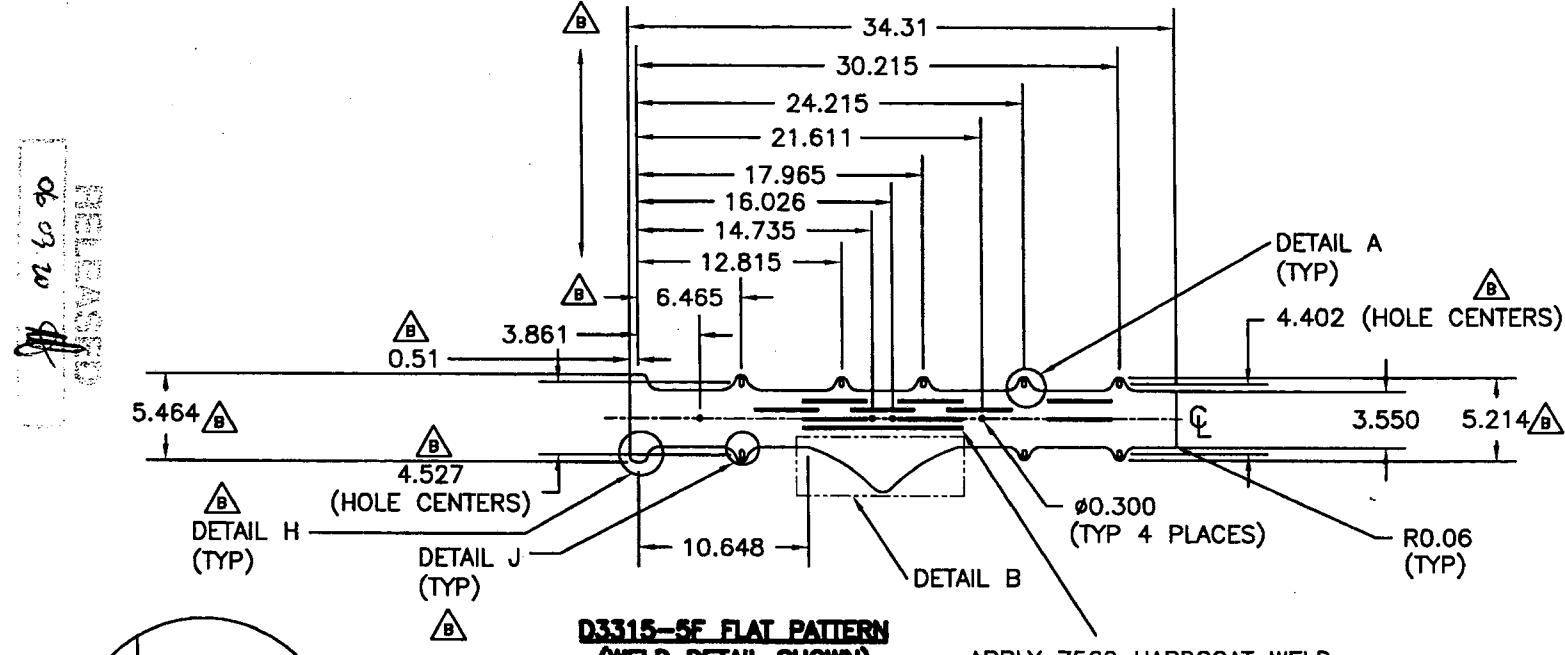
D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DESIGN	<i>P/H</i>
DRAWN BY	<i>P/H</i>
CHECKED	<i>P/H</i>
APPROVED	<i>P/H</i>
DRAWING NO.	D3315
DATE	MILE
06.01.31	WEARPLATE
SHEET 2 OF 4	
REV. B	
SCALE	
1:16	

DART

DESIGN P/N	DRAWN BY P/H	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 06.01.31	DRAWING NO. D3315	REV. B	
SCALE 1:12	ITLE WEARPLATE	SHEET 3 OF 4	SCALE 1:12



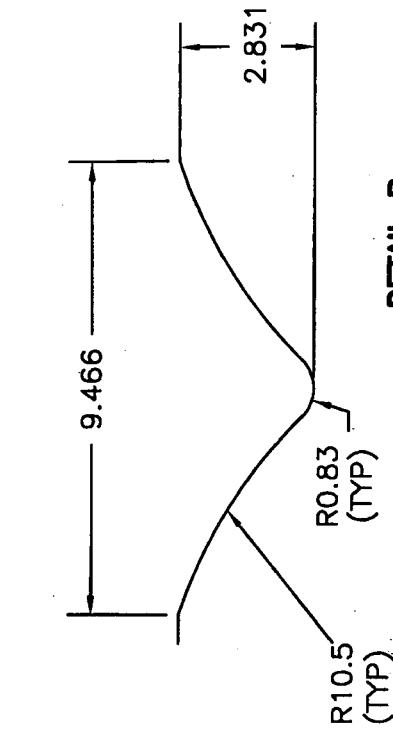
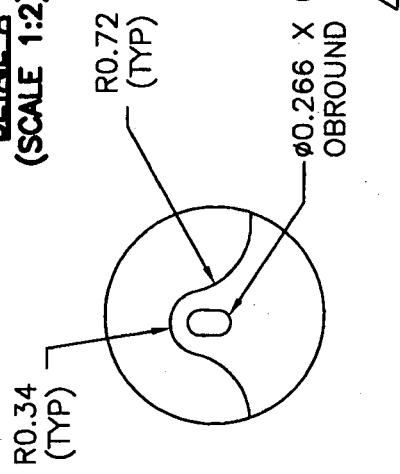
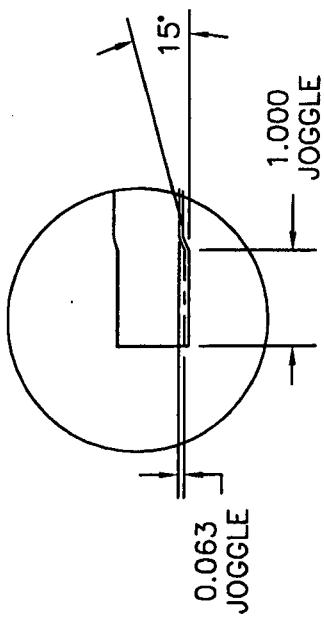
D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

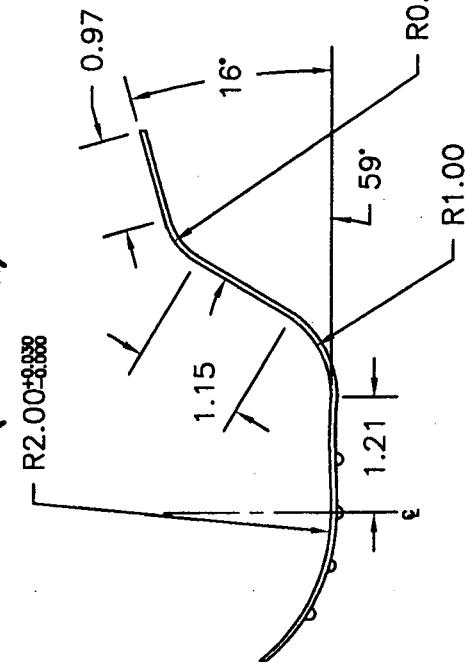
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

DETAIL A
(SCALE 1:2)**DETAIL B**
(SCALE 1:4)**DETAIL D**
(SCALE 1:2)

R2.00^{+0.000}_{-0.000}

**SECTION F-F**
(SCALE 1:2)

(-1,-2,-5,-6 ONLY)
7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH

SECTION E-E
(SCALE 1:2)

R2.00^{+0.030}_{-0.000}

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33332

0.56
(TYP)

RELEASED
06.03.20

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DART AEROSPACE LTD	Work Order:	33332
Description: WEAR PLATE	Part Number:	133154
Inspection Dwg: D33154 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: SAP
Date: 07/08/16

Audited by:	Er
Date:	27/08/16

Prototype Approval:	<i>Y</i>
Date:	

Rev	Date	Change	Revised by	Approved
1		New Issue	KJ/JLM	

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